

Patriot Duo 1:1 Unit Operations Manual

DUO-PAT-7-12-SIL



MagnumVenusPlastech

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Table of Contents

SECTION:	Page
TERMS & CONDITIONS OF SALE	4
SAFETY & WARNINGS	6
INTRODUCTION	15
GETTING STARTED	17
PRIMING THE MATERIALS	20
START-UP & SHUT-DOWN PROCEDURES	22
PATRIOT DUO FLUID SECTION REPAIR	25
PATRIOT POWER HEAD REPAIR	26
1:1 CLASSIC PRO GUN REPAIR	27
PARTS DRAWINGS	28
REVISION INFORMATION	45



Terms & Conditions of Sale:

- Customs duties, import and export licenses and certificates, if required, and all local taxes are excluded from this offer. If US state and local taxes are applicable and not included in equipment invoice, such amount may be invoiced later.
- Delivery dates or shipping schedules are approximate and based upon the most recent information available at the time of order. Dates may be adjusted upon receipt of subsequent information or modification of order. Seller will ship prior to the delivery date if possible, but not without Buyer's consent on Advanced Equipment sales.
- All contract dates and timelines begin upon receipt at MVP of customer purchase order, signed Terms and Conditions of Sale (if applicable), and down payment per quotation (if applicable).
- If shipments are delayed by the Buyer, or because the Buyer's account is in arrears, payments shall become due on the date when the Seller is prepared to make shipment. Products held by the Seller for the Buyer shall be at the risk and expense of the Buyer.
- Damages, defects or shortages must be communicated immediately to MVP. Discrepancy in pricing and/or quantities on invoices must be reported within 30 days of the invoice date. Claims made 30 days or more following the invoice date will not be honored.
- Permission to return items must be requested and granted in advance. No credit will be given if items are returned prior to requesting and receiving permission. All returns are subject to a restocking fee. The standard 15% charges may be increased or decreased depending on the reason for the return. Special ordered items may not be returned.
- Seller warrants that the mechanical operation of the goods as specified shall be free from faults in respect to materials and workmanship for a period of 12 months for parts from the date of invoice. For systems, 12 months from start-up or, if earlier, 18 months from the date of the Bills of Lading. The warranty does not cover general wear and tear or damage due to negligence or improper use. Seller's liability under the warranty shall be limited solely to repair or replacement costs, and has no responsibility for reimbursing repair cost incurred by Buyer in connection with equipment without first giving written authorization for such charges. Seller makes no express warranties except those set forth in this agreement, and disclaims all other warranties, expressed or implied, including without limitation, implied warranties of non-infringement merchantability and fitness for a particular purpose. Seller accepts no liability for loss of production, loss of profits, or other direct or indirect damages. In any claim by the Buyer



against the Seller in respect of the goods, the liability of the Seller shall be limited to the value of the goods.

- Many factors beyond Seller's control contribute to the success of Buyer's finished products, such as raw materials used to manufacture the product. Equipment is warranted to perform to specifications detailed in quotation, but Seller is not liable for quality or quantity of finished products produced by Buyer.
- The country of origin is the United States of America. Sale, installation and all rights of the parties are governed by the laws of the state of Florida. Venue with regard to any litigation shall be in Pinellas County, Florida. The parties agree to waive all rights to trial by jury as to any and all disputes.
- The goods remain the property of the Seller until full payment is received.
- Sale of equipment is subject to application and issuance of proper US Government export license and regulations, if applicable.
- Installation of equipment is responsibility of Buyer and Seller, with cost responsibility and number of days provided as detailed in original customer Quotation. Seller will provide installation supervision personnel within 30 days of customer request. If installation is delayed by the Buyer more than six months from the date of shipment, or if customer facility or material/parts are not prepared for installation, seller will invoice full installation costs, up to \$1,250 a day plus expenses, for each MVP installation technician on site. Seller has the option to waive this fee at its discretion.
- Parties shall be excused for delays caused by embargoes, acts of civil or military authorities, Acts of God, or other circumstances beyond the reasonable control of the parties. Notification of such delays must be made in writing within ten days of occurrence.
- Our agreement supersedes any previous agreement and applies in full.



SAFETY & WARNING INFORMATION:

OPERATING YOUR POLYESTER SYSTEM SAFELY



1. Introduction

Any tool, if used improperly, can be dangerous. Safety is ultimately the responsibility of those using the tool. In like manner, safe operation of polyester processes is the responsibility of those who use such processes and those who operate the equipment. This manual outlines procedures to be followed in conducting polyester operations safely. This system has been specifically designed for use of Polyester Resin, Gel-Coat, and Methyl Ethyl Ketone Peroxides (MEKP) applications. Other formulations or blends considered for use in this equipment is strictly prohibited without the expressed consent by Magnum Venus Plastech Inc. Magnum Venus Plastech cannot eliminate every danger nor foresee every circumstance that might cause an injury during equipment operation. Some risks, such as the high pressure liquid stream that exits the spray tip, are inherent to the nature of the machine operation and are necessary to the process in order to manufacture the end-product. For this reason, ALL personnel involved in polyester operations should read and understand the Safety Manual. It is very important for the safety of employees involved in the operation that equipment operators, maintenance and supervisory personnel understand the requirements for safe operation. Each user should examine his own operation, develop his own safety program and be assured that his equipment operators follow correct procedures. Magnum Venus Plastech hopes that this manual is helpful to the user and recommends that the precautions in this manual be included in any such program. Magnum Venus Plastech recommends this Safety Manual remain on your equipment at all times for your personnel safety. In addition to the manual, Magnum Venus Plastech recommends that the user consult the regulations established under the Occupational Safety & Health Act (OSHA), particularly the following sections:

1910.94 Pertaining to Ventilation.

1910.106 Pertaining to flammable liquids

1910.107 Pertaining to spray finishing operations, particularly Paragraph (m) Organic Peroxides and Dual Component Coatings.

Other standards and recognized authorities to consult are the National Fire Protection Association (NFPA) bulletins as follows:

NFPA No.33 Chapter 14, Organic Peroxides and Dual Component Materials

NFPA No.63 Dust Explosion Prevention

NFPA No.70 National Electrical Code

NFPA No.77 Static Electricity

NFPA No.91 Blower and Exhaust System

NFPA No.654 Plastics Industry Dust Hazards



Type of Fire Extinguishing equipment recommended: Fire Extinguisher – code ABC, rating number 4a60bc.

Extinguishing Media – Foam, Carbon Dioxide, Dry Chemical, Water Fog.

Copies of the above bulletins are available, at a nominal charge from:

National Fire Protection Association
470 Atlantic Avenue
Boston, MA 02210



Research Report No.11 of the American Insurance Association deal with “Fire, Explosion and Health Hazards of Organic Peroxides”. It is published by:

American Insurance Association
85 John Street
New York, NY 10038

Local codes and authorities also have standards to be followed in the operation of your spraying equipment. Your insurance carrier will be helpful in answering questions that arise in your development of safe procedures.

1.2 Personal Safety Equipment

Magnum Venus Plastech recommends the following Personal Safety Equipment for conducting safe operations of the Polyester Systems:

Magnum Venus Plastech recommends that the user consult the state and local regulations established for all Safety equipment listed.

2.0 Material Safety

2.1 Hazards Associated with Laminating Operations

The major hazards which should be guarded against in polyester laminating operations are those associated with:

1. The flammability and explosion dangers of the catalyst normally used – Methyl Ethyl Ketone Peroxide (MEKP).
2. The flammability dangers of clean-up solvents sometimes used (Magnum Venus Plastech recommends that clean-up solvents be non-flammable), and of resin diluents used, such as styrene.
3. The flammability dangers of catalyst diluents, if used. (Magnum Venus Plastech recommends that catalyst not be diluted.
4. The flammability dangers of the uncured liquid resins used.
5. The combustibility dangers of the cured laminate, accumulations of over spray, and laminate sandings.
6. The toxicity dangers of all the chemicals used in laminating operations with respect to ingestion, inhalation and skin and eye hazards.

2.2 Catalyst (Methyl Ethyl Ketone Peroxide)

MEKP is among the more hazardous materials found in commercial channels. The safe handling of the “unstable (reactive)” chemicals presents a definite challenge to the plastics industry. The highly reactive property which makes MEKP valuable to the plastics industry in producing the curing reaction of polyester resins also produces the hazards which require great care and caution in its storage, transportation, handling, processing and disposal. MEKP is a single chemical. Various polymeric forms may exist which are more or less hazardous with respect to each other. These differences may arise not only from different molecular structures (all are, nevertheless, called “MEKP”) and from possible trace impurities left from the manufacture of the chemicals, but may also arise by contamination of MEKP with other materials in its storage or use. Even a small amount of contamination with acetone, for instance, may produce an extremely shock-sensitive and explosive compound.



Contamination with promoters or materials containing promoters, such as laminate sandings, or with any readily oxidizing material, such as brass or iron, will cause exothermic “redox” reactions which can become explosive in nature. Heat applied to MEKP, or heat build-up from contamination reactions can cause it to reach what is called its Self-Accelerating Decomposition Temperature (SADT).

Researchers have reported measuring pressure rates-of-rise well in excess of 100,000 psi per second when certain MEKP's reach their SADT. (For comparison, the highest pressure rate-of-rise listed in NFPA Bulletin NO.68, “Explosion Venting”, is 12,000 psi per second for an explosion of 12% acetylene and air. The maximum value listed for a hydrogen explosion is 10,000 psi per second. Some forms of MEKP, if allowed to reach their SADT, will burst even an open topped container. This suggests that it is not possible to design a relief valve to vent this order of magnitude of pressure rate-of-rise. The user should be aware that any closed container, be it a pressure vessel, surge chamber, or pressure accumulator, could explode under certain conditions. There is no engineering substitute for care by the user in handling organic peroxide catalysts. If, at any time, the pressure relieve valve on top of the catalyst tank should vent, the area should be evacuated at once and the fire department called. The venting could be the first indication of a heat, and therefore, pressure build-up that could eventually lead to an explosion. Moreover, if a catalyst tank is sufficiently full when the pressure relief valve vents, some catalyst may spray out, which could cause eye injury. For this reason, and many others, anyone whose job puts them in an area where this vented spray might go, should always wear full eye protection even when laminating operations are not taking place.

Safety in handling MEKP depends to a great extent on employee education, proper safety instructions and safe use of the chemicals and equipment. Workers should be thoroughly informed of the hazards that may result from improper handling of MEKP, especially in regards to contamination, heat, friction and impact. They should be thoroughly instructed regarding the proper action to be taken in the storage, use and disposal of MEKP and other hazardous materials used in the laminating operation. In addition, users should make every effort to:

- A. Store MEKP in a cool, dry place in original containers away from direct sunlight and away from other chemicals.
- B. Keep MEKP away from heat, sparks and open flames.

- C. Prevent contamination of MEKP with other materials, including polyester over spray and sandings, polymerization accelerators and promoters, brass, aluminum and non-stainless steels.
- D. Never add MEKP to anything that is hot, since explosive decomposition may result.
- E. Avoid contact with skin, eyes and clothing. Protective equipment should be worn at all times. During clean-up of spilled MEKP, personal safety equipment, gloves and eye protection must be worn. Firefighting equipment should be at hand and ready.
- F. Avoid spillage, which can heat up to the point of self-ignition.
- G. Repair any leaks discovered in the catalyst system immediately, and clean up the leaked catalyst at once in accordance with the catalyst manufacturer's instructions.
- H. Use only original equipment or equivalent parts from Magnum Venus Plastech in the catalyst system (i.e.: hoses, fitting, etc.) because a dangerous chemical reaction may result between substituted parts and MEKP.
- I. Catalyst accumulated from the purging of hoses or the measurement of fluid output deliveries should never be returned to the supply tank, such catalyst should be diluted with copious quantities of clean water and disposed of in accordance with the catalyst manufacturer's instructions.



The extent to which the user is successful in accomplishing these ends and any additional recommendations by the catalyst manufacturer determines largely the safety that will be present in his operation.

2.3 Clean-Up Solvents and Resin Diluents

WARNING

A hazardous situation may be present in your pressurized fluid system! Hydrocarbon Solvents can cause an explosion when used with aluminum or galvanized components in a closed (pressurized) fluid system (pump, heaters, filters, valves, spray guns, tanks, etc.). The explosion could cause serious injury, death and/or substantial property damage. Cleaning agents, coatings, paints, etc. may contain Halogenated Hydrocarbon Solvents. Some Magnum Venus Plastech spray equipment includes aluminum or galvanized components and will be affected by Halogenated Hydrocarbon Solvents.

- A. There are three key elements to the Halogenated Hydrocarbon (HHC) solvent hazard.
 - a. The presence of HHC solvents. 1,1,1 – Trichloroethane and Methylene Chloride are the most common of these solvents. However, other HHC solvents are suspect if used; either as part of paint or adhesives formulation, or for clean-up flushing. b. Aluminum or Galvanized Parts. Most handling equipment contains these elements. In contact with these metals, HHC solvents could generate a corrosive reaction of a catalytic nature.
 - b. Equipment capable of withstanding pressure. When HHC solvent contacts aluminum or galvanized parts inside a closed container such as a pump, spray gun, or fluid handling system, the chemical reaction can, over time, result in a build-up of heat and pressure, which can reach explosive proportions.

When all three elements are present, the result can be an extremely violent explosion. The reaction can be sustained with very little aluminum or galvanized metal; any amount of aluminum is too much.

A. The reaction is unpredictable. Prior use of an HHC solvent without incident (corrosion or explosion) does NOT mean that such use is safe. These solvents can be dangerous alone (as a clean-up or flushing agent) or when used as a component or a coating material. There is no known inhibitor that is effective under all circumstances. Furthermore, the mixing of HHC solvents with other materials or solvents, such as MEKP, alcohol, and toluene, may render the inhibitors ineffective.

B. The use of reclaimed solvents is particularly hazardous. Reclaimers may not add any inhibitors. Also, the possible presence of water in reclaimed solvents could feed the reaction.

C. Anodized or other oxide coatings cannot be relied upon to prevent the explosive reaction. Such coatings can be worn, cracked, scratched, or too thin to prevent contact. There is no known way to make oxide coatings or to employ aluminum alloys, which will safely prevent the chemical reaction under all circumstances.

D. Several solvent suppliers have recently begun promoting HHC solvents for use in coating systems. The increasing use of HHC solvents is increasing the risk. Because of their exemption from many State Implementation Plans as Volatile Organic Compounds

(VOC's), their low flammability hazard, and their not being classified as toxic or carcinogenic substances, HHC solvents are very desirable in many respects.



WARNING: Do not use Halogenated Hydrocarbon solvents in pressurized fluid systems having aluminum or galvanized wetted parts.

NOTE: Magnum Venus Plastech is aware of NO stabilizers available to prevent Halogenated Hydrocarbon solvents from reaction under all conditions with aluminum components in closed fluid system. TAKE IMMEDIATE ACTION... Halogenated Hydrocarbon solvents are dangerous when used with aluminum components in a closed fluid system.

A. Consult your material supplier to determine whether your solvent or coating contains Halogenated Hydrocarbon Solvents.

B. Magnum Venus Plastech recommends that you contact your solvent supplier regarding the best non-flammable clean-up solvent with the heat toxicity for your application.

C. If, however, you find it necessary to use flammable solvents, they must be kept in approved, electrically grounded containers.

D. Bulk solvent should be stored in a well-ventilated, separate building, 50 feet away from your main plant.

E. You should allow only enough solvent for one day's use in your laminating area.

F. "NO SMOKING" signs must be posted and observed in all areas of storage or where solvents and other flammable materials are used.

G. Adequate ventilation (as covered in OSHA Section 1910.94 and NFPA No.91) is important wherever solvents are stored or used, to minimize, confine and exhaust the solvent vapors.

H. Solvents should be handled in accordance with OSHA Section 1910.106 and 1910.107.

2.4 Catalyst Diluents

Magnum Venus Plastech spray-up and gel-coat systems currently produced are designed so that catalyst diluents are not required. Magnum Venus Plastech, therefore, recommends that diluents not be used. This avoids the possible contamination which could lead to an explosion due to the handling and mixing of MEKP and diluents. In addition, it eliminates any problems from the diluents being contaminated through rust particles in drums, poor quality control on the part of the diluents suppliers, or any other reason. If, however, diluents are absolutely required, contact your catalyst supplier and follow his instructions explicitly. Preferable, the supplier should premix the catalyst to prevent possible “on the job” contamination while mixing.

WARNING

If diluents are not used, it should be remembered that catalyst spillage, gun, hose and packing leaks are potentially more hazardous, since each drop contains a higher concentration of catalyst, and therefore will react quicker with over spray and the leak.

2.5 Cured Laminate, Overspray and Laminate Sandings Accumulation

A. Remove all accumulations of overspray, FRP sandings, etc. from the building as they occur. If this waste is allowed to build up, spillage of catalyst is more likely to start a fire; in addition, the fire would burn hotter and longer.

B. Floor coverings, if used, should be non-combustible.

C. Spilled or leaked catalyst may cause a fire if it comes in contact with an FRP product, over-sprayed chop or resin, FRP sandings or any other material with MEKP.

To prevent this spillage and leakage, you should:

1. Maintain your Magnum Venus Plastech System. Check the gun several times daily for catalyst and resin packing or valve leaks. REPAIR ALL LEAKS IMMEDIATELY.
2. Never leave the gun hanging over, or lying inside the mold. A catalyst leak in this situation would certainly damage the part, possibly the mold, and may cause a fire.
3. Inspect resin and catalyst hoses daily for wear or stress at the entry and exits of the boom sections and at the hose and fittings. Replace if wear or weakness is evident or suspected.
4. Arrange the hoses and fiberglass roving guides so that the fiberglass strands DO NOT rub against any of the hoses at any point. If allowed to rub, the hose will be cut through, causing a hazardous leakage of material which could increase the danger of fire. Also, the material may spew onto personnel in the area.

2.7 Toxicity of Chemicals

- A. Magnum Venus Plastech recommends that you consult OSHA Sections 1910.94, 1910.106, 1910.107 and NFPA No.33, Chapter 14, and NFPA No.91.
- B. Contact your chemical supplier(s) and determine the toxicity of the various chemicals used as well as the best methods to prevent injury, irritation and danger to personnel.
- C. Also determine the best methods of first aid treatment for each chemical used in your plant.

2.8 Treatment of Chemical Injuries

Great care should be used in handling the chemicals (resins, catalyst and solvents) used in polyester systems. Such chemicals should be treated as if they hurt your skin and eyes and as if they are poison to your body. For this reason, Magnum Venus Plastech recommends the use of protective clothing and eye wear in using polyester systems. However, users should be prepared in the event of such an injury. Precautions include:

1. Know precisely what chemicals you are using and obtain information from your chemical supplier on what to do in the event the chemical gets onto your skin or into the eyes, or is swallowed.
2. Keep this information together and easily available so that it may be used by those administering first aid or treating the injured person.
3. Be sure the information from your chemical supplier includes instructions on how to treat any toxic effects the chemicals have.

WARNING



Contact your doctor immediately in the event of any injury and give him the information you have collected. If your information includes first aid instructions, administer first aid immediately while you are contacting your doctor.

Fast treatment of the outer skin and eyes that contact such chemicals generally includes immediate and thorough washing of the exposed skin and immediate and continuous flushing of the eyes with lots of clean water for at least 15 minutes or more. These general instructions of first aid treatment, however, may be incorrect for some chemicals; that is why you must know the chemicals and treatment before an accident occurs. Treatment for swallowing a chemical frequently depends upon the nature of the chemical.

NOTE: Refer to your System User Manual for complete and detailed operating instructions and service information.

3.0 Equipment Safety

WARNING

Magnum Venus Plastech suggests that personal safety equipment such as EYE GOGGLES, GLOVES, EAR PROTECTION, and RESPIRATORS be worn when servicing or operating this equipment. Ear protection should be worn when operating a fiberglass chopper to protect against hearing loss since noise levels can be as high as 116 dB (decibels). This equipment should only be operated or serviced by technically trained personnel!

WARNING

Never place fingers, hands, or any body part near or directly in front of the spray gun fluid tip. The force of the liquid as it exits the spray tip can cause serious injury by shooting liquid through the skin. NEVER LOOK DIRECTLY INTO THE GUN SPRAY TIP OR POINT THE GUN AT OR NEAR ANOTHER PERSON. (TREAT THE GUN AS IF IT WERE A LOADED PISTOL.)

3.1 Emergency Stop Procedures

The following steps should be followed in order to stop the machinery in an emergency situation

1. The ball valve located where the air enters the power head of the resin pump, should be moved to the "OFF" or closed position. To do this, simply rotate the lever on the ball valve 90 degrees. Doing this will cause all the system air to bleed out of the system in a matter of a few seconds, making the system incapable of operating

NOTE: Step 2 is a precautionary step and should be followed whenever the above mentioned ball valve is activated to the stop mode. Failure to do so, can damage the regulators and components on reactivating to the "ON" position.

2. Turn all system regulators to the "OFF" position (counter-clockwise) position

NOTE: Verify that the Catalyst relief line, located on the catalyst manifold, and the resin return line, located on the resin filter, are secured relieving catalyst and resin fluid pressure.

3. Catalyst pressure in the catalyst pump can be eliminated by rotating the ball valve on the catalyst manifold 90 degrees to the "open" or "on" position.

Note: The "open" or "on" position is when the ball valve handle is parallel (in line) with the ball valve body. The "closed" or "off" position is when the ball valve handle is perpendicular (across) the ball valve body.



4. Resin pressure in the resin pump can be eliminated by rotating the ball valve on the resin filter 90 degrees to the "open" or "on" position. Place a container under the ball valve to catch any resin that is ejected out of the valve.

3.2 Grounding

Grounding an object means providing an adequate path for the flow of the electrical charge from the object to the ground. An adequate path is one that permits charge to flow from the object fast enough that it will not accumulate to the extent that a spark can be formed. It is not possible to define exactly what will be an adequate path under all conditions since it depends on many variables. In any event, the grounding means should have the lowest possible electrical resistance. Grounding straps should be installed on all loose conductive objects in the spraying area. This includes material containers and equipment. Magnum Venus Plastech recommends grounding straps be made of AWG No.18 stranded wire as a minimum and the larger wire be used where possible. NFPA Bulletin No77 states that the electrical resistance of such a leakage path may be as low as 1 meg ohm (10 ohms) but that resistance as high as 10,000 meg ohms will produce an adequate leakage path in some cases. Whenever flammable or combustible liquids are transferred from one container to another, or from one container to the equipment, both containers or container and equipment shall be effectively bonded and grounded to dissipate static electricity. For further information, see **National Fire Protection Association** (NFPA) 77, titled "Recommended Practice on Static Electrical". Refer especially to section 7-7 titled "Spray Application of Flammable and Combustible Materials". Check with local codes and authorities for other specific standards that might apply to your application. NEVER USE HARD MATERIALS SUCH AS WIRE, PINS, ETC., TO CLEAR A PLUGGED GUN. HARD MATERIALS CAN CAUSE PERMANENT DAMAGE. DAB WITH A BRISTLE BRUSH, BLOW BACKWARDS WITH AIR UNTIL CLEAR WHILE WEARING A PROTECTIVE EYE SHIELD. REPEAT AS MANY TIMES AS NECESSARY. DO NOT PERFORM ANY MAINTENANCE OR REPAIRS UNTIL YOU HAVE FOLLOWED THE PRECAUTIONS STATED ABOVE. IF YOU, AS AN EQUIPMENT OPERATOR OR SUPERVISOR, DO NOT FEEL THAT YOU HAVE BEEN ADEQUATELY TRAINED OR INSTRUCTED AND THAT YOU LACK THE TECHNICAL KNOWLEDGE TO OPERATE OR PERFORM MAINTENANCE ON A PIECE OF MAGNUM VENUS PLASTECH EQUIPMENT, PLEASE CALL MAGNUM VENUS PLASTECH BEFORE OPERATING OR PERFORMING MAINTENANCE ON THE EQUIPMENT. IF YOU HAVE ANY QUESTIONS REGARDING THE ABOVE PRECAUTIONS OR ANY SERVICE OR OPERATION PRECEDURES, CALL YOUR MAGNUM VENUS PLASTECH DISTRIBUTOR OR MAGNUM VENUS PLASTECH.

NOTICE: *All statements, information and data given herein are believed to be accurate and reliable but are presented without guaranty, warranty or responsibility of any kind express or implied. The user should not assume that all safety measures are indicated or that other measures are not required.*

DANGER: *Contaminated catalyst may cause Fire or Explosion. Before working on the catalyst pump or catalyst accumulator, wash hands and tools thoroughly. Be sure work area is free of dirt, grease or resin. Clean catalyst system components with clean water only.*

DANGER: Eye, skin and respiration hazard. The Catalyst, MEKP, may cause blindness, skin irritation or breathing difficulty. Keep hands away from face. Keep food and drink away from work area.

WARNING: Please refer to your catalyst manufacturer's safety information regarding the safe handling and storage of catalyst. Wear appropriate safety equipment as recommended.



Introduction:

The Patriot Duo 1:1 Unit comes in two configurations Spatter and Pour. Most of the procedures will be the same between the two configurations but any differences will be noted.

This manual provides information needed to properly operate and perform simple maintenance and repair on this equipment.

- ☐ Step-by-step operations procedures are provided.
- ☐ This manual includes Installation, Start-up and Shut-Down instructions.
- ☐ Step-by-step assembly and disassembly procedures are included for each component.

Please read this manual carefully. Follow the steps in the order given, otherwise you may damage the equipment or injure yourself.

Major Components:

The Patriot Duo 1:1 Unit consists of the following major components:

- ☐ Duo Patriot – Fluid Sections (PAT-LS-12770-D)
- ☐ 7" Patriot Power Head – Duo Pump (PAT-PH-7000-D)
- ☐ Classic Pro DUO Gun – Spatter (CPD-5000-SNZ)

Description of Controls for Unit:

Familiarize yourself with the Air Manifold controls, which consist of the following regulators and gauges:

- ☐ PUMP PRESSURE gauge and regulator. This controls the main air pressure to the resin pump Air Motor.
- ☐ PRIMING BUTTON push button control. This control allows the pump to operate with out opening the gun. The Priming Button sends an air signal to the pump control valve which allows control air to the power head.
- ☐ MAIN AIR INLET VALVE – This is the main air inlet ball valve. This ball valve is used to turn off air supply to the unit. It also releases the air pressure in the unit.

Note: Open the Main Air Ball Valve in one full stroke open or closed if partially opened air will leak from the exhaust port on the valve.



Spatter:

- ❑ SPATTER AIR NOZZLE PRESSURE gauge and regulator. This controls the air pressure to the Spatter Nozzle assembly. Increasing the Spatter Nozzle pressure will help break the material into smaller particles.

Fluid Pressure:

- ❑ FLUID PRESSURE GAUGE – This displays the fluid pressure for each of the two components. These are located at the Outlet of each of the component pumps.



Getting Started:

Air Requirements:

Clean, dry compressed air must be available at 90 – 100 psi (6 – 7 bar) and a minimum volume of 10 -14 CFM (.3 – .4 m³/min.). Air must be provided through an air hose with a diameter of 0.5 inch (1.3 cm) or greater.

Lubrication:

Throughout this manual, directions are given for lubricating various parts. There are four types of lubricant used:

- ☐ If the part contacts resin, use MVP Red Grease (6706-2-1).
- ☐ If the part is located where it will contact air, use Lubriplate® (08465).
- ☐ Throat Seal Oil (PAT-LS-OIL) used in the oil reservoir of the fluid sections.
- ☐ Gun Oil (6706-3-1) for Pro gun repair and maintenance

Other Supplies:

- ☐ Solvent for cleaning.
- ☐ A small Chip / Paint Brush for cleaning.
- ☐ Sealable container for the solvent large enough for cleaning gun and pump part.
- ☐ Medium Thread Locker (Removable Loctite® 243 or equivalent)
- ☐ Spare Mixer Element (07550)



Installation and Setup:

1. Unpack unit & components – report any damaged or missing items
2. Install Fluid Tanks and connect to corresponding component pump.
3. Attach Gun and hose set to their respective connections, Component A Hose to Component A Pump Outlet, Component B Hose to Component B Pump Outlet, Air Supply from Gun Handle to the Air manifold and Air Signal (green poly tube) from the front of the gun to Pump Control Valve on the Air manifold.
4. Double check all hose fittings and connections are tight.

Note: it is important to be sure all fittings and connections are tight to prevent air and fluids from leaking.



Installation and Setup: (Continued)

5. Connect the Air supply to the unit. Be sure all regulators are at zero (counter clockwise).
6. Fill the Oil reservoir / Packing Nut on the Fluid sections 3/4 full of Throat Seal Oil (TSL-3200) or suitable oil. Snug the Packing nut tight but do not over tighten.
7. Open the Main Air valve and check for air leaks.

Note: Open the Main Air Ball Valve in one full stroke open or closed if partially opened air will leak from the exhaust port on the valve.

8. Pull the trigger on the 1:1 Pro gun several (3 – 5) times.
9. Using the “T” bit tool snug the packing nuts on the gun block. Repeat procedures 8 - 9 several times. This will properly seat the seals in the Pro Gun Block.
10. Test the pump operation – pull the trigger on the gun and at the same time slowly turn up the pump regulator until the pump is moving slowly and evenly.
11. Release the gun trigger and the pump will stop.
12. Press the Priming Button on the air manifold and the pump will begin to cycle again – release the Priming Button and the pump will stop.
13. Turn the Pump regulator back to zero (all the way counter clockwise)

The unit is tested and is ready to Prime.



Priming the Unit:

Priming Material to Gun:

1. Check and fill the Oil Reservoirs / Packing Nut cavity 3/4 full with TSL oil or suitable oil.
2. Fill Component Supply Tanks with correct materials.
3. Remove the Spatter Nozzle assembly (SNZ-1000) or Mixer assembly from the front of the Mix chamber of the gun.
4. Position the Mix Chamber over the appropriate container.
5. Pull the Trigger on the gun and hold or lock the Trigger in the on position; slowly increase Pump pressure until the pump is cycling at a slow but steady rate. Allow pump to run until a steady stream of both materials is being dispensed.
6. Close the gun and wipe any extra material from the front of the Mix chamber and install the Mixer assembly or Spatter Nozzle assembly.

Alternate Priming Procedure:

Wastes a little less material by recirculating the materials back to their original containers.

Perform the procedures 1-3 from above then:

4. Remove one of the material hoses from the back of the gun block and remove the tape holding the hoses together so you can separate the hose.
5. Unscrew the top from the material tanks.
6. Position the gun and loose hose over the correct material containers

Caution: Make sure you position the gun and hose over the correct containers to be sure to not to contaminate the material in the container, keep dirt out the containers.

7. Hold or lock the Trigger in the on position; slowly increase Pump pressure until the pump is cycling at a slow but steady rate. Allow pump to run until a steady stream of both materials is being dispensed back into their original containers.
8. Release the trigger and allow the any extra material to drain from the open hose end.



9. Clean the hose end and reconnect to the back of the gun block.
10. Replace the Material tank lids.
11. Pull the trigger on the gun to get both materials to the front of the gun.
12. Close the gun and wipe any extra material from the front of the Mix chamber and install the Mixer assembly or Spatter Nozzle assembly.



Daily Procedures:

See the following pages – Copy or Print and distribute as needed for the operators.

DAILY START-UP for PATRIOT DUO 1:1 UNIT

ACTIVITIES MUST BE DONE IN THE SEQUENCE SHOWN, AND MUST BE CHECKED OFF AS COMPLETED.

ACTIVITY NO.	ACTIVITY	CHECK AS COMPLETED
Priority	Put on Respirator as specified for spray painting, Protective Clothing, Eye Protection, and PVC Gloves	
1	Check all hoses for damage or wear.	
2	Check all material supplies and fill or replace as needed.	
3	Open Main Inlet air valve on the Air manifold.	
4	Check resin pump pressure, if needed press and hold the Priming Button while slowly adjust the pump air pressure to the desired operating pressure.	
5	Install a new Mixer Element into the Mixer assembly or Spatter Nozzle assembly and install onto the Mix chamber.	
6	Peel / remove any cure material from the front of the Spatter Nozzle assembly	
7	Dispense a small amount of material into a waste container to balance the two materials.	

THE UNIT IS NOW READY FOR USE

ABNORMAL CONDITIONS OBSERVED AND CORRECTED

Abnormal Condition	✓ when corrected

OPERATORS NAME _____ DATE: _____

SIGN OFF WHEN START-UP CHECKS ARE COMPLETED: _____

DAILY SHUT-DOWN for PATRIOT DUO 1:1 UNIT

ACTIVITIES MUST BE DONE IN THE SEQUENCE SHOWN, AND MUST BE CHECKED OFF AS COMPLETED.

ACTIVITY NO.	ACTIVITY	CHECK AS COMPLETED
Priority	Put on Respirator as specified for spray painting, Protective Clothing, Eye Protection, and PVC Gloves	
1	Turn off the Main air ball valve at the Air manifold.	
2	Check the Weep Holes on the top of the gun block for leaking material – tighten the Packing nuts as needed.	
3	Hang the gun with the front of the gun facing downwards. There is no need to wipe the front of the Spatter Nozzle assembly clean because it is easy to peel Silicon and similar materials after they cured	

ABNORMAL CONDITIONS OBSERVED AND CORRECTED

Abnormal Condition	✓ when corrected

OPERATORS NAME _____ DATE: _____

SIGN OFF WHEN SHUT DOWN CHECKS ARE COMPLETED: _____



Fluid Section Repair:

The Patriot Duo 1:1 Unit uses two of the Patriot Duo Fluid Section (PAT-LS-12270-D) – for repair and maintenance instructions reference the manual “**Patriot 1-1/4 Fluid Section Manual – PAT-LS-12270**”





Powerhead Repair:

The Patriot Duo 1:1 Unit uses the 7" Patriot Power Head – for repair and maintenance instructions reference the manual **“Patriot Powerhead Manual PAT-PH-7000”**





Classic Pro Gun Repair:

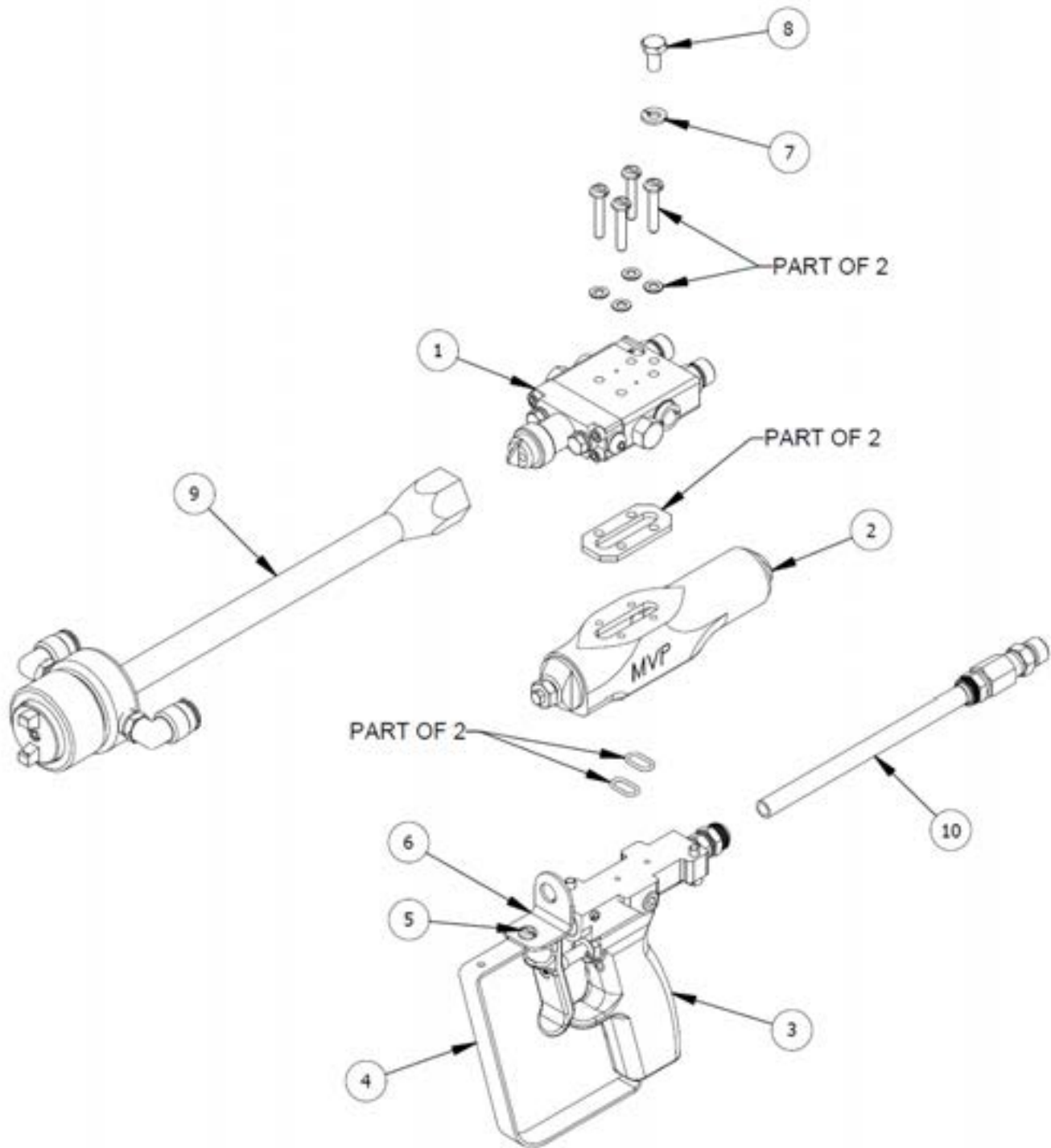
The Patriot Duo 1:1 Unit uses the 1:1 Classic Pro Gun Assembly (CPD-5000-SNZ) – for repair and maintenance instructions reference the manual “**CPD / PRTM - 1:1 Classic Pro Gun Manual**”





Parts Drawings:

CPD-5000-SNZ	1:1 CLASSIC PRO DUO - SPATTER
CPD-5100-SNZ	PRO DUO GUN BLOCK
SNZ-1000	SPATTER NOZZLE ASSEMBLY
PAT-PA-DUO-15750	DUO PATRIOT PUMP ASSEMBLY
PAT-LS-12770-D	DUO PATRIOT FLUID SECTION
MLM-BRKT-TK-400	TANK BRACKET ASSEMBLY
MA-36	AIR MANIFOLD ASSEMBLY
PAT-PH-7000-D	7" PATRIOT POWER HEAD - DUO



MAGNUM VENUS PLASTECH

PRO DUO GUN

CPD-5000-SNZ

REV:

SHEET 1 / 2

3/18/2010

Parts List			
ITEM	PART NUMBER	QTY	DESCRIPTION
1	CPD-5100-SNZ	1	PRO DUO GUN BLOCK
2	58604-1	1	ACTUATOR ASSY WITH SIGNAL
3	58603-3	1	CLASSIC PRO HANDLE ASSY. - GEL
4	58670-1	1	TRIGGER GUARD
5	02806-2	1	10-24 PAN HEAD SCREW
6	58671-1	1	DRIP SHIELD
7	F-SW-04	1	LOCK WASHER
8	F-HB-04C-08	1	HEX BOLT
9	SNZ-1000	1	SPATTER NOZZLE ASSEMBLY
10	6506-1-0.5	1	POLY AIR WHIP

REPAIR KIT

CPD-5000-SNZ-RK (REPAIR KIT INCLUDES PARTS IN ITEMS 1, 2, 3, AND 9)

MAGNUM VENUS PLASTECH

PRO DUO GUN

CPD-5000-SNZ

REV:

SHEET 2 / 2

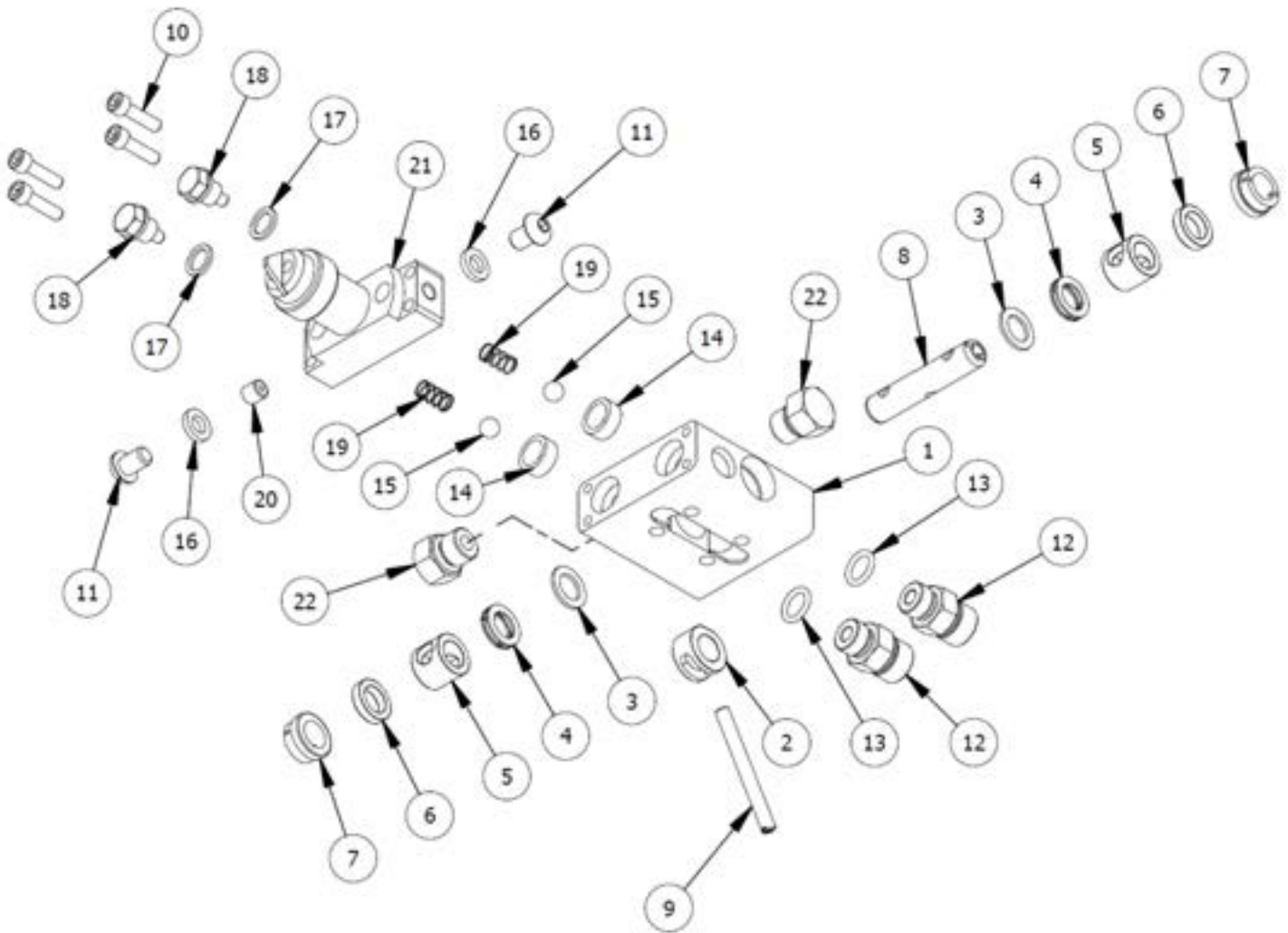
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MagnumVenusPlastech

Rev. 07/2012

Page | 30



MAGNUM VENUS PLASTECH

PRO DUO GUN BLOCK

CPD-5100-SNZ

REV:

SHEET 1 / 2

3/18/2010

Parts List			
ITEM	PART NUMBER	QTY	DESCRIPTION
1	58691-1	1	1:1 GUN HEAD
2	5104-10-1	1	CENTER SPACER
3	5104-3-1	2	SECONDARY SEAL
4	5104-4-1	2	RELIEF SPACER
5	5104-5-1	2	RESIN SEAL
6	5104-7-1	2	PACKING RING
7	5104-8-1	2	PACKING NUT
8	58693-1	1	VALVE ROD
9	5104-11-1	1	ACTUATING STEM
10	F-CS-832-10-GR8	4	SOCKET HEAD CAP SCREW
11	F-BHCS-04C-06	2	BUTTON HEAD CAP SCREW
12	5104-9-1	2	RESIN FITTING
13	O-E-3-904	2	O-RING
14	58694-1	2	CHECK FACE SEAL
15	03199	2	SS BALL
16	02441-1	2	SEAL - GUN HEAD PLUG
17	58695-1	2	PLUG SEAL
18	58696-1	2	PLUG
19	04319	2	COMPRESSION SPRING
20	58752-4	1	FLOW RESTRICTOR
21	DUO-4101	1	1:1 MIXER ADAPTER
22	F-SP-07F	2	SOLVENT PLUG

OPTIONAL PARTS

PART NUMBER	QTY	DESCRIPTION
O-E-012	2	O-RING (REPLACES BLACK O-RING ON F-SP-07F) THIS IS INCLUDED IN CPD-5000-SNZ-RK KIT

MAGNUM VENUS PLASTECH

PRO DUO GUN BLOCK

CPD-5100-SNZ

REV:

SHEET 2 / 2

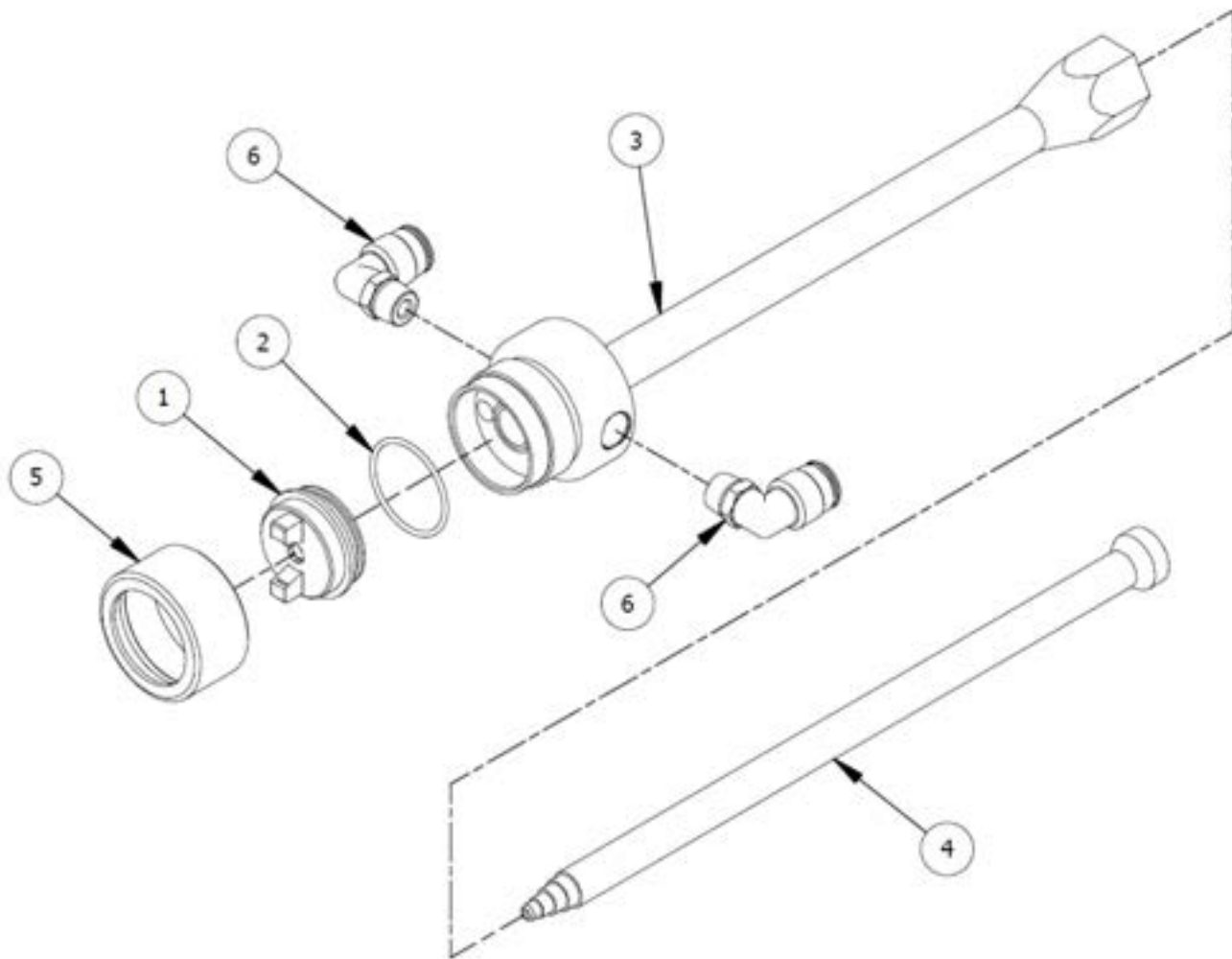
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MagnumVenusPlastech

Rev. 07/2012

Page | 32



NOTE: DO NOT DISASSEMBLE ITEM 3

MAGNUM VENUS PLASTECH

SPATTER NOZZLE ASSEMBLY

SNZ-1000

REV:

SHEET 1 / 2

6/1/2010

Parts List			
ITEM	PART NUMBER	QTY	DESCRIPTION
1	SNZ-1001	1	NOZZLE
2	O-E-026	1	O-RING
3	SNZ-1002-01	1	MIXER-CAP ASSEMBLY
4	07550	1	DISPOSABLE MIXER
5	VPA-1003	1	CAP RETAINER
6	07234	2	MALE POLY ELBOW

MAGNUM VENUS PLASTECH

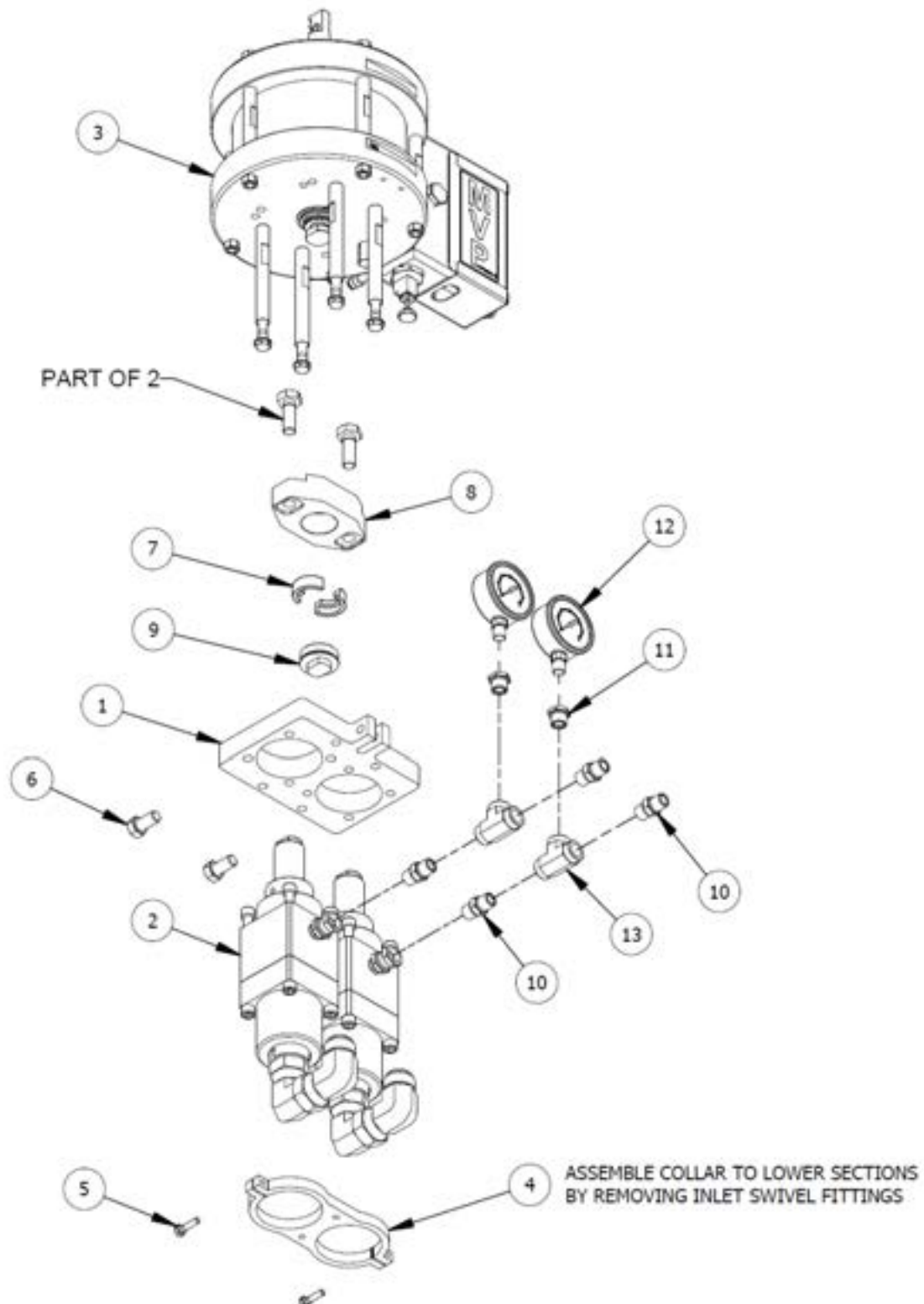
SPATTER NOZZLE ASSEMBLY

SNZ-1000

REV:

SHEET 2 / 2

6/1/2010



MAGNUM VENUS PLASTECH

PUMP ASSEMBLY

PAT-PA-DUO-15750

REV:

SHEET 1 / 2

1/29/2010

Parts List			
ITEM	PART NUMBER	QTY	DESCRIPTION
1	PAT-LS-1021	1	TRANSITION PLATE
2	PAT-LS-12270-D	2	FLUID SECTION ASSY - DUO
3	PAT-PH-7000-D	1	POWER HEAD ASSY - 7"
4	PAT-LS-1022	1	STABILIZER CLAMP
5	F-HB-04C-16	2	HEX BOLT
6	F-HB-08C-16	2	HEX BOLT
7	PAT-PH-7014-HD	2	HALF SHELL
8	PAT-PH-7015-HD	1	CROSS BAR
9	PAT-PH-7016-HD	1	SHELL PLUG
10	PF-HN-06	4	HEX NIPPLE
11	PF-RB-06-04	2	BUSHING
12	MRD-1005-3000	2	3000 LB. GAUGE
13	PF-FT-06	2	FEMALE TEE

MAGNUM VENUS PLASTECH

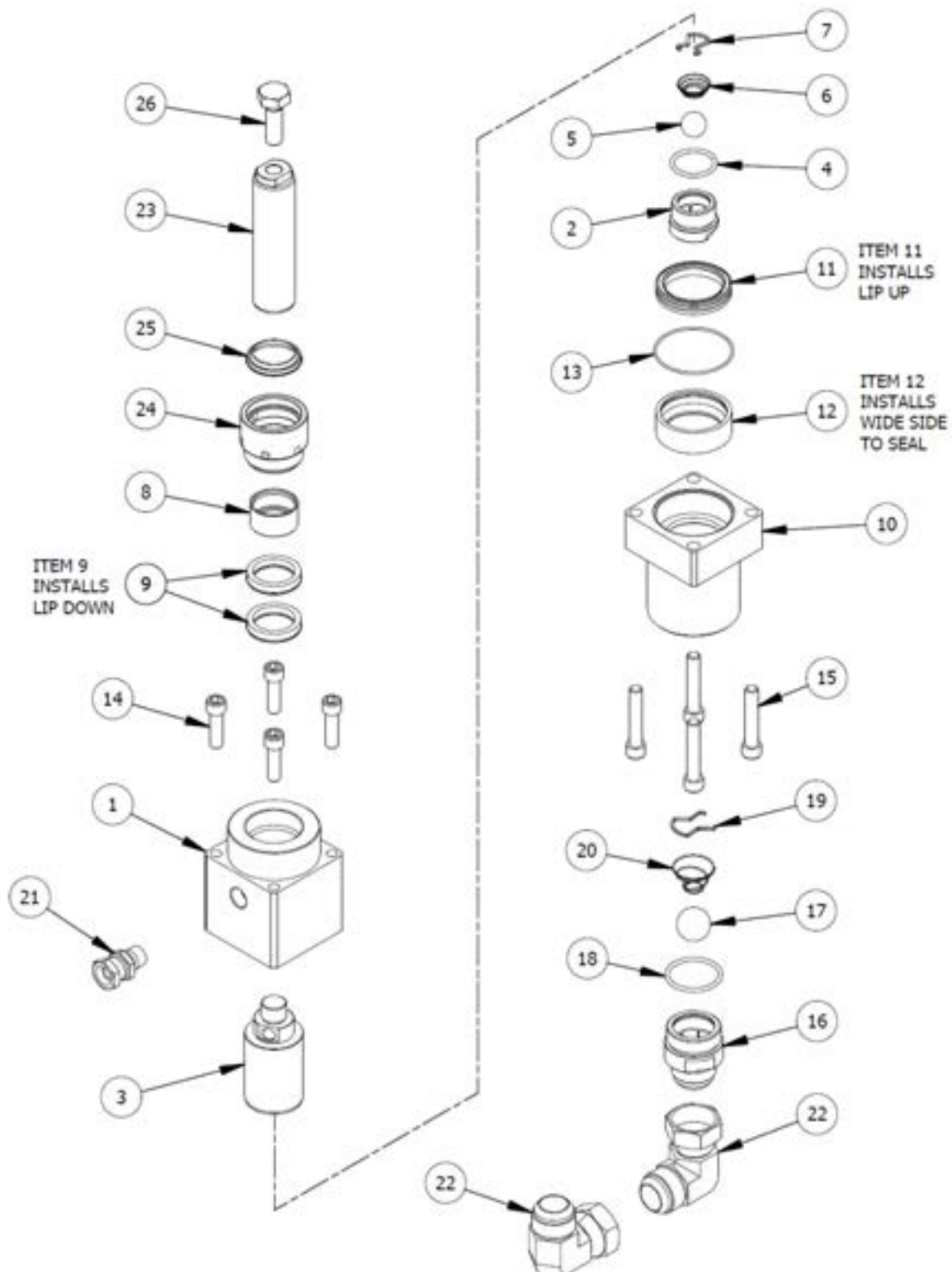
PUMP ASSEMBLY

PAT-PA-DUO-15750

REV:

SHEET 2 / 2

1/29/2010



MAGNUM VENUS PLASTECH

FLUID SECTION - DUO PUMP

PAT-LS-12270-D

REV:

SHEET 1 / 2

1/28/2010

Parts List			
ITEM	PART NUMBER	QTY	DESCRIPTION
	1 PAT-LS-1001	1	OUTLET BODY
	2 PAT-LS-1009	1	PISTON VALVE
	3 PAT-LS-1007	1	PISTON
*	4 O-E-3-916	1	O-RING
	5 VLS-2427	1	3/4" CHROME BALL
	6 PAT-LS-1010	1	SPRING
	7 PAT-LS-1011	1	SPRING RETAINER
	8 PAT-LS-1005	1	ROD BUSHING
*	9 PAT-LS-1016	2	ROD SEAL ASSY
	10 PAT-LS-1002	1	INLET BODY
*	11 PAT-LS-1014	1	PISTON SEAL ASSY
	12 PAT-LS-1013	1	PISTON BUSHING
*	13 O-E-035	1	O-RING
	14 F-CS-06C-20	4	CAP SCREW
	15 F-CS-06C-32	4	CAP SCREW
	16 PAT-LS-1015	1	INLET VALVE
	17 PAT-LS-1017	1	1" CHROME BALL
*	18 O-E-3-920	1	O-RING
	19 VLS-2420	1	BALL STOP
	20 3102-16-1	1	FOOT VALVE SPRING
	21 PF-SW-06	1	PIPE SWIVEL
	22 PF-SE-SW-16J	2	SWIVEL ELBOW JIC
	23 PAT-LS-1028	1	FLUID ROD
	24 PAT-LS-1019	1	PACKING NUT
	25 PAT-LS-1020	1	SCRAPER SEAL
	26 F-HB-08F-24-GR5	1	HEX BOLT

REPAIR KITS

PART No.	DESCRIPTION
* PAT-LS-12270-SK	SEAL KIT

* NOTE: ASTERISKS DENOTE PARTS USED IN SEAL KIT

MAGNUM VENUS PLASTECH

FLUID SECTION - DUO PUMP

PAT-LS-12270-D

REV:

SHEET 2 / 2

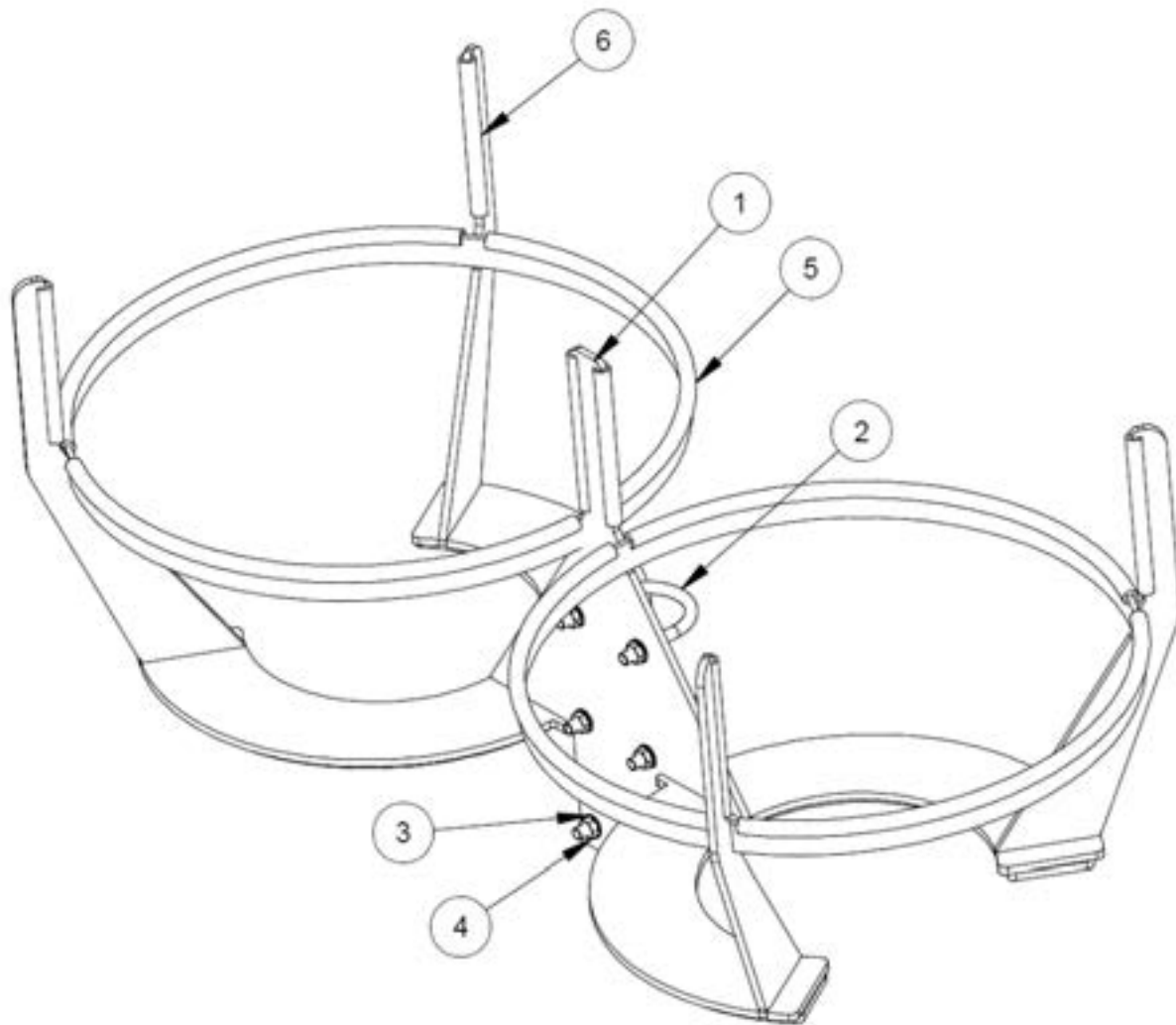
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MagnumVenusPlastech

Rev. 07/2012

Page | 38



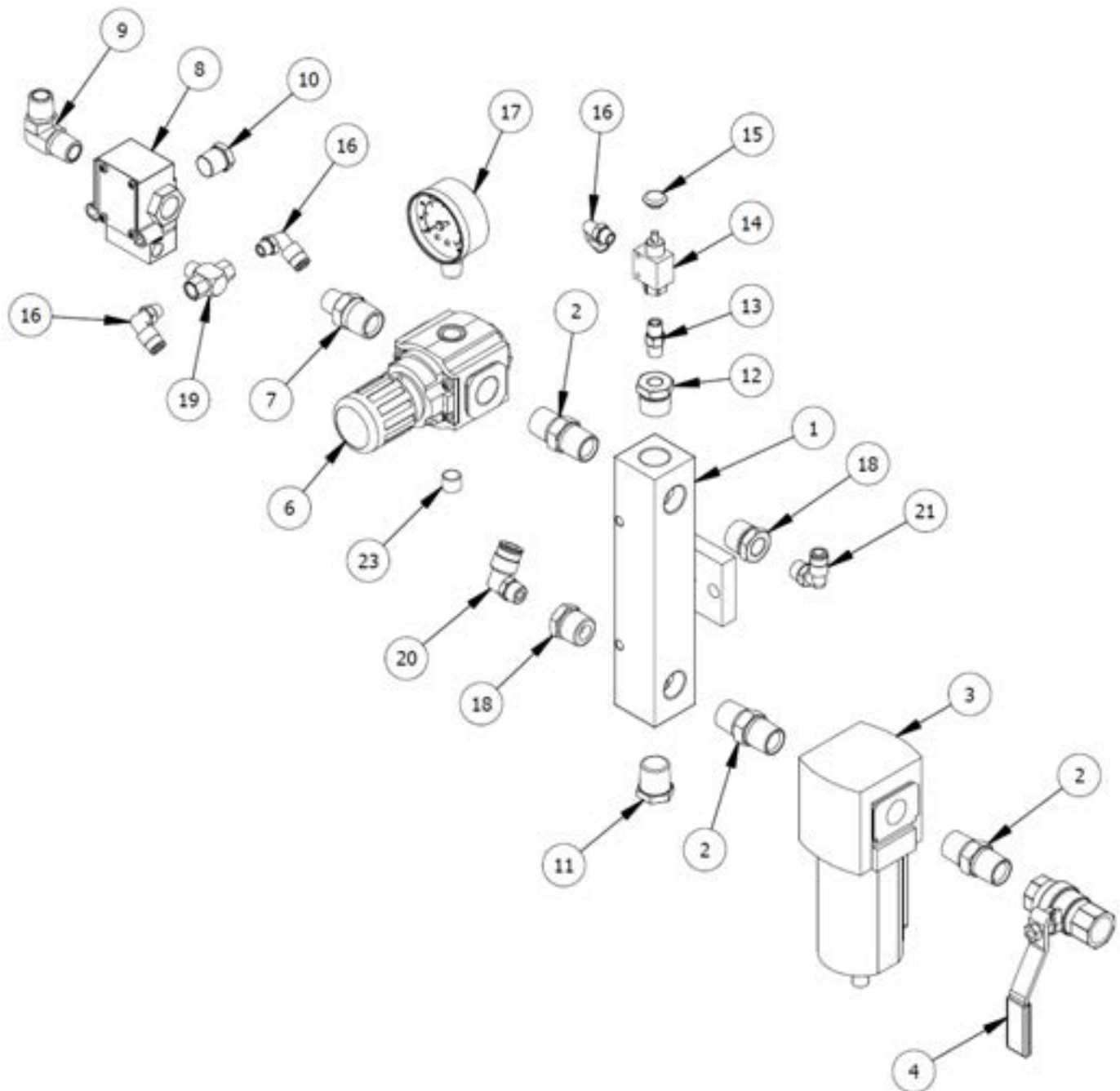
Parts List			
ITEM	PART NUMBER	QTY	DESCRIPTION
1	MLM-BRKT-TK-1	1	TANK BRACKET
2	F-UB-06C-40	3	U-BOLT
3	F-FW-06	6	3/8 FLAT WASHER
4	F-HN-06C	6	HEX NUT
5	MVP-1008-19	6	EDGE TRIM
6	MVP-1008-5.5	6	EDGE TRIM

MAGNUM VENUS PLASTECH

TANK BRACKET ASSEMBLY

MLM-BRKT-TK-400

REV:07-03-08



MAGNUM VENUS PLASTECH

AIR MANIFOLD

MA-36

REV:

SHEET 1 / 2

2/8/2010

Parts List			
ITEM	PART NUMBER	QTY	DESCRIPTION
1	MA-2001	1	MANIFOLD W/ BRKT
2	PF-HN-08	3	HEX NIPPLE
3	8404-1-1	1	FILTER
4	7702-2-2	1	BALL VALVE 1/2 NPT
6	8405-1-1	1	REGULATOR
7	PF-HN-08-06	1	HEX NIPPLE
8	PV-101	1	PILOTED MAC VALVE 2-WAY
9	PF-ME-06	1	MALE ELBOW
10	PF-HP-06	1	HEX PIPE PLUG
11	PF-HP-08	1	HEX PLUG
12	7701-3-34	1	REDUCER BUSHING
13	PF-HN-02	1	HEX NIPPLE
14	8407-4-1	1	3-WAY VALVE
15	8407-5-1	1	PUSH BUTTON
16	MPH-2539	3	MALE ELBOW
17	AG-B2-160	1	AIR GUAGE
18	PF-RB-08-04	2	REDUCER BUSHING
19	8407-3-1	1	SHUTTLE VALVE
20	07234	1	MALE POLY ELBOW
21	07233	1	MALE POLY ELBOW
23	PF-AP-04	1	ALLEN PLUG

MAGNUM VENUS PLASTECH

AIR MANIFOLD

MA-36

REV:

SHEET 2 / 2

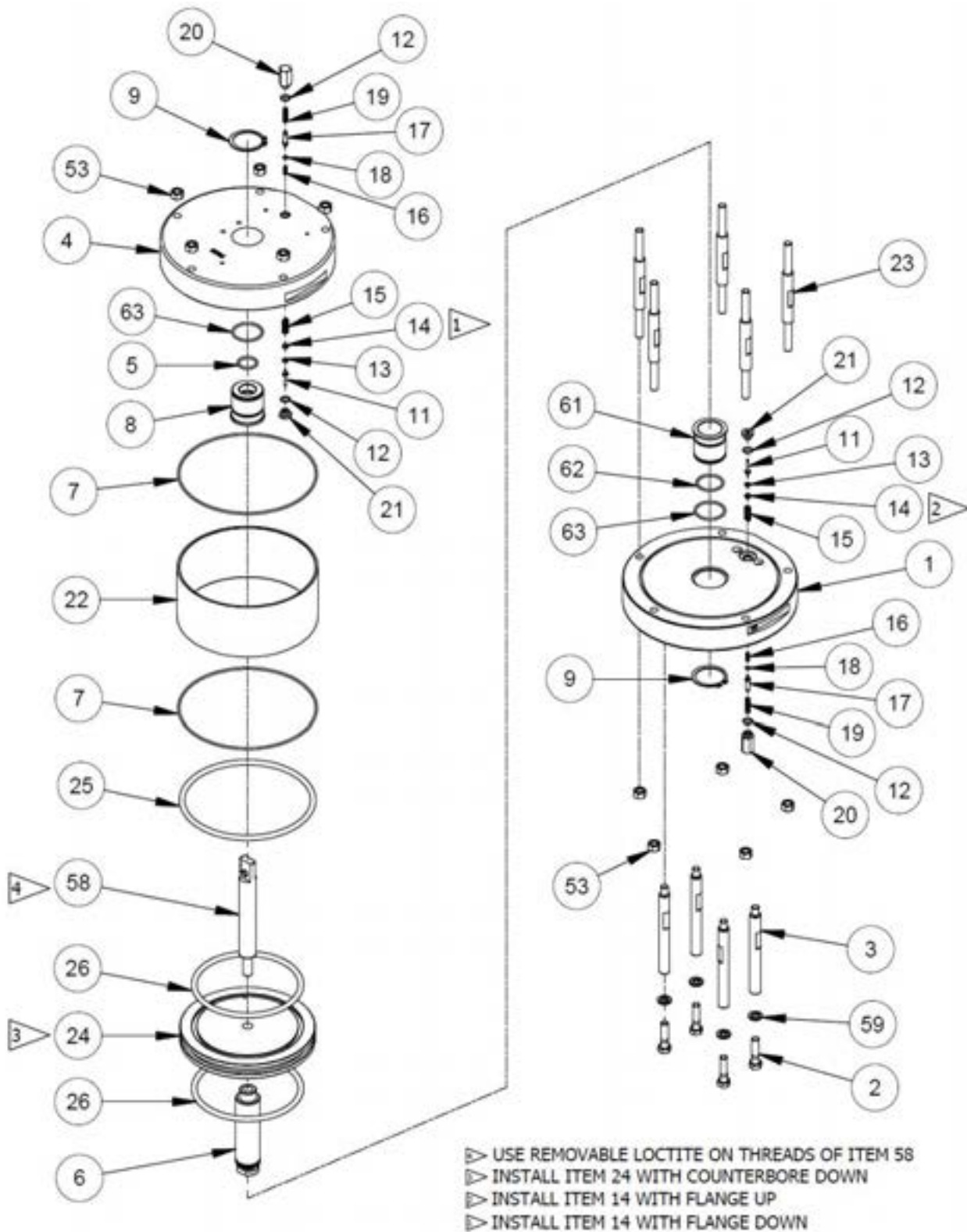
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MagnumVenusPlastech

Rev. 07/2012

Page | 41



MAGNUM VENUS PLASTECH

7" PATRIOT POWER HEAD -DUO PUMP

PAT-PH-7000-D

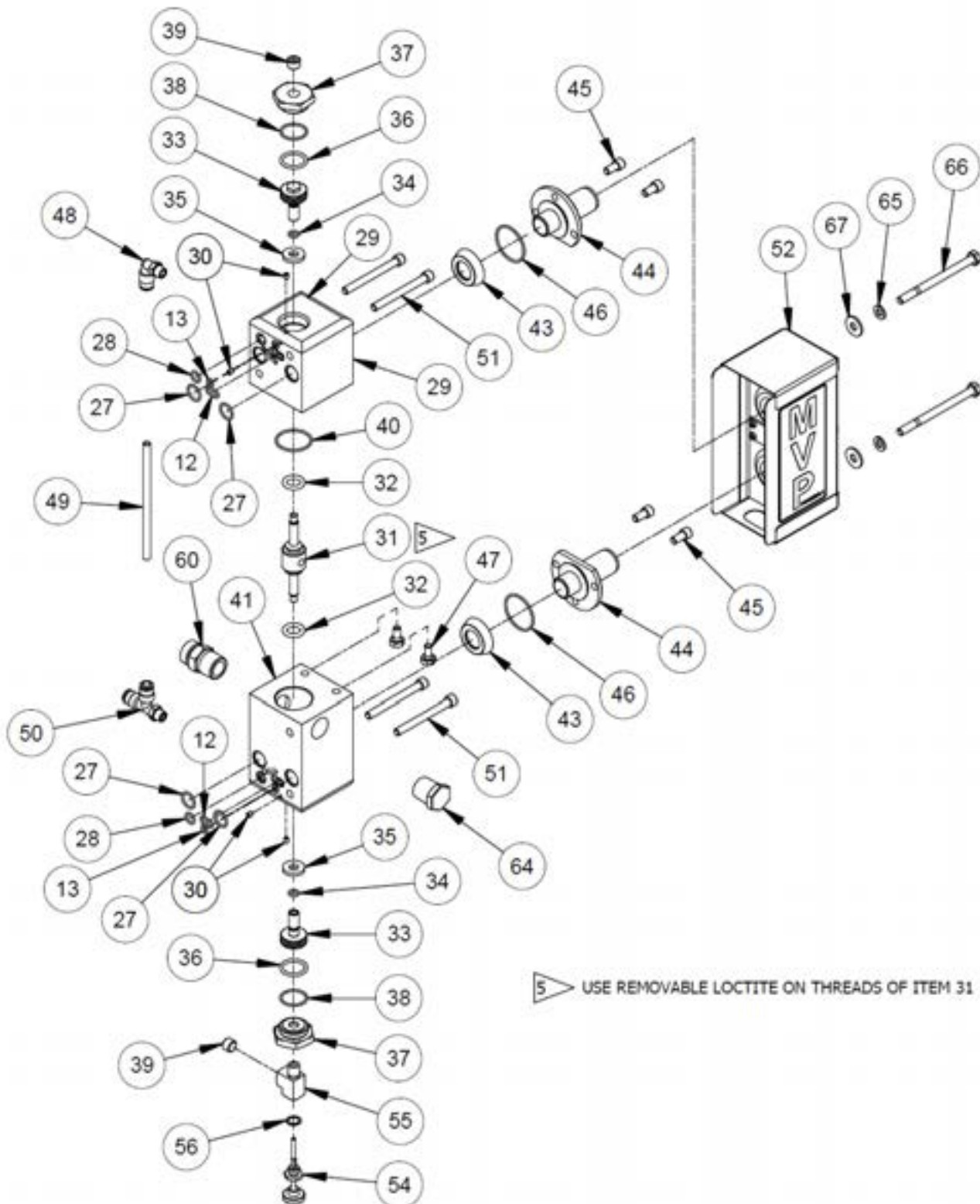
REV: 01-28-10 BT2



MagnumVenusPlastech

Rev. 07/2012

Page | 42



MAGNUM VENUS PLASTECH

7" PATRIOT POWER HEAD - DUO PUMP PAT-PH-7000-D

REV: 01-28-10 BT2

PAT-PH-7000-D PARTS LIST

ITEM	PART NUMBER	QTY	DESCRIPTION
1	PAT-PH-7004-HD	1	LOWER END CAP
2	F-HB-06C-24-GR8	4	HEX BOLT
3	PAT-PH-7013	4	LOWER TIE ROD
4	PAT-PH-7012	1	UPPER END CAP - 7"
* 5	O-B-118	1	O-RING
6	PAT-PH-7009	1	LOWER ROD - HD
* 7	O-B-167	2	O-RING
8	PAT-PH-5007	1	UPPER BUSHING
9	7205-2-26	2	EXTERNAL SNAP RING
11	MPH-2513	2	VALVE STEM- PILOT VALVE
* 12	O-B-012	6	O-RING
* 13	O-B-008	4	O-RING
14	MPH-2512	2	SEAL GUIDE- PILOT VALVE
15	MPH-2528	2	SPRING
16	MPH-2526	2	SPRING
17	MPH-2540	2	INLET ROD- PILOT VALVE
* 18	O-U-006	2	O-RING
19	MPH-2533	2	COMPRESSION SPRING
20	MPH-2541	2	SPRING HOUSING- PILOT VALVE
21	MPH-2511-01	2	STEM SEAL ASSY- PILOT VALVE
22	PAT-PH-7003	1	CYLINDER
23	PAT-PH-5006	5	TIE ROD - 2" STROKE
24	MPH-7004	1	PISTON - 7"
* 25	O-B-439	1	O-RING
* 26	O-B-431	2	O-RING
* 27	O-B-014	4	O-RING
* 28	O-B-011	2	O-RING
29	PAT-PH-5001	1	UPPER VALVE BLOCK
30	F-SS-832-02-SS	4	SET SCREW
31	PAT-PH-5005	1	POCKET VALVE - 2" STROKE
* 32	O-U-206-90	2	O-RING
33	MPH-2517	2	VALVE PISTON
* 34	O-D-010-90	2	O-RING
35	MPH-3262	2	PISTON STOP
* 36	O-B-116	2	O-RING
37	MPH-2521	2	VALVE END CAP
* 38	O-B-019	2	O-RING
39	PF-AP-02-SS	2	PIPE PLUG
* 40	O-B-024	1	O-RING
41	PAT-PH-5002	1	LOWER VALVE BLOCK
* 43	MPH-5010	2	DIAPHRAGM
44	MPH-5009	2	EXHAUST PORT
45	F-CS-04C-08-SS	4	CAP SCREW
* 46	O-B-026	2	O-RING
47	F-HB-04C-08	2	HEX BOLT
48	MPH-2539	1	MALE ELBOW
49	MS-2052-1	40ft	POLY TUBE
50	MPH-2538	1	MALE POLY TEE FITTING
51	F-CS-04C-40-SS	4	CAP SCREW
52	PAT-PH-5010-01	1	MUFFLER ASSEMBLY
53	F-HN-06F	10	HEX NUT
54	MPH-2546-01	1	RESET VALVE STEM
55	PF-ST-02-8R	1	TEE FITTING
56	MPH-2545	1	SEAL
58	PAT-PH-5008	1	UPPER ROD ASSY
59	F-SW-06	4	LOCK WASHER
60	PF-HN-08-08S	1	HOSE ADAPTER
61	MPH-7005	1	BUSHING
* 62	O-B-124	1	O-RING
* 63	O-B-127	2	O-RING
64	PF-HP-08	1	HEX PLUG
65	F-SW-04-SS	2	LOCK WASHER
66	F-HB-04C-56-SS	2	HEX BOLT
67	F-FW-04	2	FLAT WASHER

OPTIONAL PARTS AND ASSEMBLIES

PARTS LIST

PART No.	QTY	DESCRIPTION
MPH-2542	1	RESET BUTTON ASSY
PAT-PH-SB-XL	1	SHIFT BLOCK ASSY

REPAIR KITS

PART No.	DESCRIPTION
* PAT-PH-7000-HD-SK	SEAL KIT

* ASTERISKS DENOTE PARTS IN SEAL KIT

MAGNUM VENUS PLASTECH

7" PATRIOT POWER HEAD - DUO PUMP PAT-PH-7000-D

REV: 01-28-10 BT2



MagnumVenusPlastech

Rev. 07/2012

Page | 44



Revision Information:

Revision:**Description:**

Rev. 05/2010 Created Manual

Rev. 04/2011 Updated the drawings in the manual. Added the alternate priming procedures.

Rev: 07/2012 Updated the manual format and Address. Added the Terms & Conditions of Sale section to the manual.





MAGNUM VENUS PLASTECH

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Included with this operations manual are the following component manuals:

- ☐ PATRIOT 1-1/4" FLUID SECTION MANUAL PAT-LS-12270
- ☐ PATRIOT POWER HEAD MANUAL PAT-PH-7000
- ☐ 1to1 CLASSIC PRO GUN MANUAL

Rev. 07/2012